Wednesday, 7/11/2007 2:49:04 PM Kim Johnston .User: **Process Sheet** : LUG BRACKET **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 33488 Estimate Number : 10009 : NA Part Number : D27351 P.O. Number : D2735 REV C S.O. No. : NA : 7/11/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. : SMALL /MED FAB **Drawing Revision** First Issue Type : NIV Material Previous Run 🚽 30 Um: Each : 7/31/2007 **Due Date** Written By Checked & Approved By 05-10-25 JLM : Est Rev: 6 Removed from 9 Digit Comment EC 06.09.19 est rev D waterjet **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: 1010-1025 sheet .125 M1010S125 1.0 0.1733\_sf(s)/Unit \_ Jotal : 5.1975 sf(s) Comment: Qty.: 1010-1025 sheet .125 Comment: FLOW WATER JET 1-Cut as per Dwg D2735 (D2735-1) Dwg Rev: \_\_C\_ 07/08/08 Prog Rev:\_\_\_\_ 2-Deburr if necessary QC2 3.0 67-07-20 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 4.0 Comment: SECOND CHECK NC BRAKE BRAKE NC Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required.

Dart Ae	rospac	e Ltd						
W/O:			WORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		, ,	,					
		\$ <del>[</del> ]	•					
Part No	: Dé	2735-1 PAR #: WA	Fault Category: Food Fres Ass	NCR: Yes				7111/06
				, QA: N	N/C Close	d: 🕸	Date: _	07.11.06
NCR:	3348	<u>හ</u>	ORK ORDER NON-CONFORMAN	NCE (NC	₹)			
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description Chief Eng Chief Eng	Sign 8	Sect	<b>cation</b> ion C	Approval Chief Eng	Approval QC Inspector
A-08-07		All PArts Scripp. Parts were not bent correctly the angle bench was not performed be for ethe Rodins	Replace on the worley	30 57-08 et 340	- CB (1)	<b>n</b>		
,000,	5.0	bent correctly the angle bend was not performed be for a the Rockis bend, which resultation a book fit. A she to a chim the DTB 204 die, de gouges were made in the loss, son	es established in G.A. to tropics on bend process	ain 58/09	128	1.1.	Posions	1708.08
*		the holes lootance theman ervor: improper bonding process	OT BROY	em sport	20/2	110102		

NOTE: Date & initial all entries

Date:

Wednesday, 7/11/2007 2:49:04 PM

Uses:

, Kirn Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 33488

Part Number: D27351

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



QC21 8.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



rospace L	td								
		WC	ORK ORDER CHANG	SES	<del></del> :				
STEP	STEP PROC		NGE	Ву	<i>,</i> [	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:	PAR #:	Fault Cate	gory:	_ NCR: Y	es No	DQ	A:	Date:	
		WORK ORDI	ER NON-CONFORM	ANCE (N	CR)			·	
OTED	Description of NC		Corrective Action Sec			Verifi	ration	Approval	Approval
STEP Section A		Initial Chief Eng	Action Description Chief Eng		gn & 📗			Chief Eng	QC Inspector
	STEP	PAR #:	STEP PROCEDURE CHA  PAR #: Fault Cate  WORK ORDI  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  WORK ORDER NON-CONFORM  WORK ORDER NON-CONFORM  STEP Description of NC Section A Section Description	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Y  WORK ORDER NON-CONFORMANCE (NOTE OF THE NOTE OF THE	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By C  PAR #: Fault Category: NCR: Yes No QA: N/C  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Corrective Action Section B Section A Initial Action Description Sign &	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQ QA: N/C Close  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Corrective Action Section B Verifits Section A Initial Action Description Sign & Sertion Section B Sectio	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty  :PAR #:Fault Category:NCR: Yes No DQA: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #:Fault Category:NCR: Yes No DQA:Date:QA: N/C Closed:Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33488
Description: Lug Bracket	Part Number:	D2735-1
Inspection Dwg: D2735 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

•	X	First Artic	le	Proto	type
Drawing	Tolerance	Actual	Accept	Reject	Metho
Dimension	Tolerance	Dimension	Accept	INCIPOL	Inspec

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			mspection	
0.41	+/-0.030	.409	<b>X</b>			
6.594	+/-0.010	6.594	, x			
R0.63	+/-0.030	R.63	Y			
1.750	+/-0.010	1750	<b>X</b>			
Ø0.438	+0.006/-0.001	Ø 440	*			
0.75	+/-0.030	מה	.)≰			
R1.00	+/-0.030	R. 1,00	*			·
1.50	+/-0.030	1.50	*			
0.125	+/-0.010	,126	×			
						A STATE OF THE STA
				:		e e co

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Measured by:	IB.	Audited by:	CP	Prototype Approval:	N/A
Date:	16-10-10	Date:	07/12/23	Date:	N/A

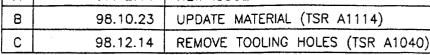
Rev	Date	Change	Revised by	Approved
Α	07.02.02	New Issue	KJ/JLM	L <i>S</i> /11/

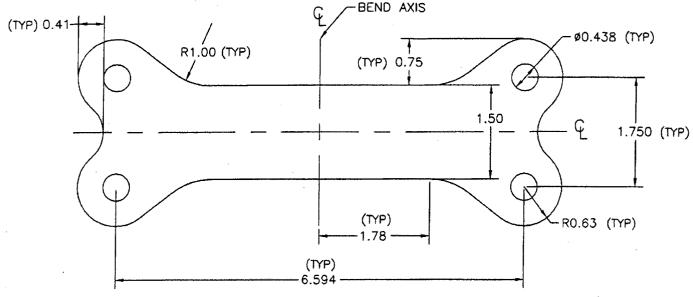




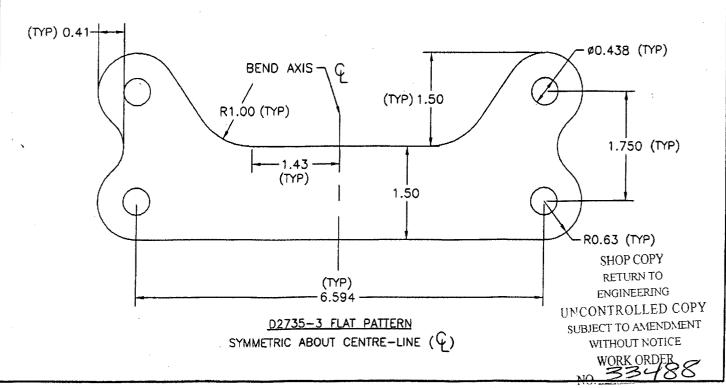
DESIG	#-	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED	APPROVED	DRAWING NO. REV.	С
	P	KE	D2735 SHEET 1 OF	. 2
DATE			TITLE SCA	LF.
98.1	12.14		LUG BRACKET	2:3
Α	•	97.12.14	NEW ISSUE	
В		98.10.23	UPDATE MATERIAL (TSR A1114)	

## RELEASED 18812-14 DS



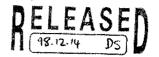


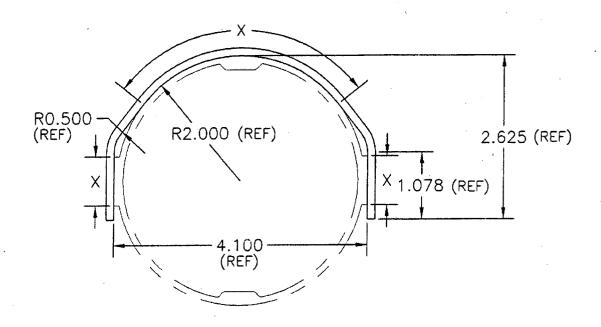
## D2735-1 FLAT PATTERN SYMMETRIC ABOUT BOTH CENTRE-LINES $(\mathcal{C})$





DESIGN	DRAWN BY	DART AEROS HAWKESBURY, OH	
CHECKED	APPROVED KE	DRAWING NO.	REV. C SHEET 2 OF 2
DATE	<del></del>	TITLE	SCALE
98.12.14		LUG BRACKET	2:3





D2735-1 AND D2735-3 BEND DETAIL
D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SHOP COPY ALL DIMENSIONS ARE IN INCHES

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER 8

DART AEROSPACE LTD	Work Order: 33488
Description: Lug Bracket	Part Number: 02735- )
Inspection Dwg: D2035 Rev: C	Page 1 of 1

napection Dwg	•	ARTICLE IN	SPECTIO	ON CHE	CKLIST	
	X	First Artic	le	Proto	type	
Drawing Dimer sion	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.41	7-0.030	0.41			Vern	
6.594	140.010	6.600			Vern	
RO.63	+40,030	RO.68	/		R-6	
1,750	+1-0.010	1.756			Vern	
80.438	10.006/-0.001	00.438	4		Vern	
0,75	+/-0.030	0 74	J		Verh	
R1.00	+60.030	R1.00			R-6	
1.50	+1-0.010	1.50	/		Vern	
9.125	+1.0.000	6.117			Vern	
					A STATE OF THE STA	
					j.	
easured by:	SAD A	udited by:	0	Pr	ototype Appro	oval: 1/
Date:	22/08/08	Date: 0	7/08/08			Date: VA
lev Date	Change		110-10		Rev	vised by Approved
A	New Issue					JLM